

# Work Order ID 69025

Wednesday, April 27, 2011 10:57:09 AM



Page 1

Item ID: D3953-9

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Washer

Stop



Start Date: 4/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA855 & DWG

FOLIO REV: C

DWG REV: C

DEBURR

115119

21

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

115119

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 2

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Item ID: D3953-9

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Revision ID:

Stop



Item Name: Gas Spring Washer

Start Date: 4/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11.5.19

21

130

Identify as per dwg &amp; Stock Location: 96

0.00



Packaging

Memo

0.00

Packaging

11/5/19 20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/19

11-08-19

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# Picklist Print

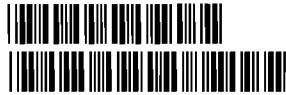
Wednesday, April 27, 2011 10:57:16 AM

Page 1

Work Order ID: 69025

Parent Item: D3953-9

Parent Item Name: Gas Spring Washer



Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue 09.10.13 DD verified by:EC  
as per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDELRLNR0.750

Purchased

No

100

f

74.1000

0.05

1.053632



SD 11/5/11

Delrin Round Bar 0.75"

Location

Loc Qty

Loc Code

MAT055

74.1

115472

7.5

116183

3.6

117273

56

117322

7

.3 pt

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**Dart Aerospace Ltd**

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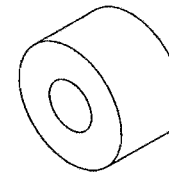
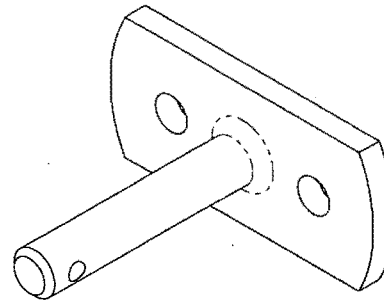
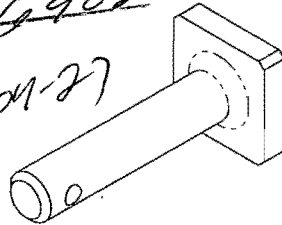
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**NOTE:** Date & initial all entries



SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 69025



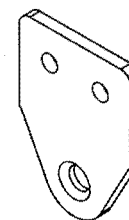
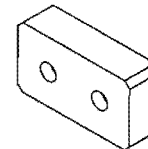
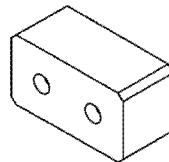
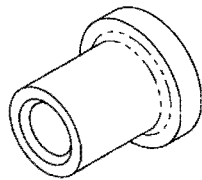
**D3953-1 GAS SPRING BRACKET**  
 (FULL LID)

**D3953-3 GAS SPRING STUD, LID**

**D3953-5 GAS SPRING STUD, BASE**

**D3953-7 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER**



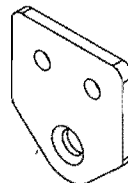
**D3953-11 GAS SPRING SPACER**

**D3953-13 GAS SPRING SPACER**  
 (FULL LID)

**D3953-15 GAS SPRING BRACKET**  
 (SPLIT LID)

**D3953-17 GAS SPRING SPACER**  
 (SPLIT LID)

**D3953-19 GAS SPRING BRACKET**  
 (SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
 (SQUARE BASKET)

**RELEASED**  
 2010-02-26

C	PARTS -19 & -21 ADDED (SHT 1&4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); 6 SYMM WAS & SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3953</b>	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

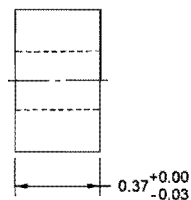
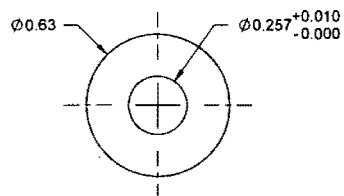
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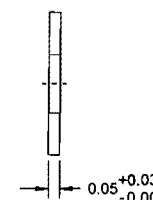
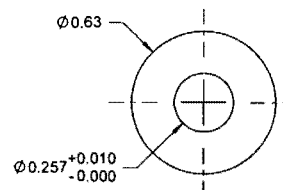
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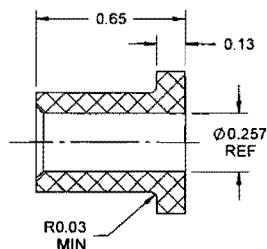
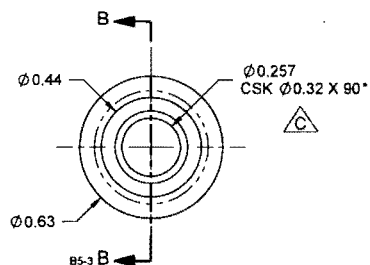
**NOTE:** Date & initial all entries



**D3953-7 GAS SPRING SPACER**

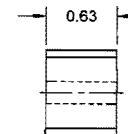
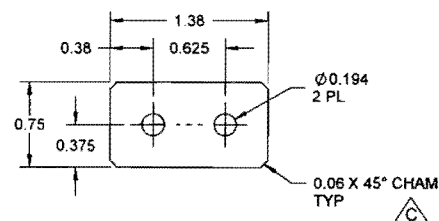


**D3953-9 GAS SPRING WASHER**



**SECTION B-B** B7-3

**D3953-11 GAS SPRING SPACER**



**D3953-13 GAS SPRING SPACER**

**NOTES:**

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK  
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

*u/o 69025*

**RELEASED**  
2010-02-26

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISSEMINATION OF THIS DOCUMENT TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD IS PROHIBITED.	

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